

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. A putter head consisting of fused and annealed glass.
- 5 2. The putter head of Claim 1, wherein the glass further comprises:
soda lime glass with an expansion rating of either 90 COE or 96 COE.
- 10 3. The putter head of Claim 2, further comprising:
an admixture of clear glass and colored glass.
- 15 4. The putter head of Claim 2, further comprising:
an admixture of transparent glass and opaque glass.
- 20 5. The putter head of Claim 2, wherein fused glass comprises:
glass that is fired to fuse glass pieces into an integral whole.
6. The putter head of Claim 5 wherein fused glass further comprises:
glass that is fired in a kiln from room temperature to about 649 °C to obtain a glass putter head melt in about 6 hours; holding the glass melt for about 30 minutes at about 649 °C, heating one hour to about 807 °C; and holding for about 40 minutes at about 807 °C.
- 25 7. The putter head of Claim 2, wherein annealed glass comprises:
glass annealed by gradual cooling to remove internal stresses occasioned by the temperature differential between the core and the surface of the putter head.
- 30 8. The putter head of Claim 7, where annealed glass further comprises:
glass annealed by cooling a fused glass in about 20 minutes to about 510 °C; holding for about two hours at 510 °C; cooling about four and a half hours to 410 °C; holding for about two hours at 410 °C; cooling about seven hours to about 66 °C; holding for about 5 minutes at about 66 °C; then turning the kiln off and allowing glass putter heads to cool to room temperature..
- 35 9. The putter head of Claim 2, further comprising:
a bas-relief design.

10. The bas-relief design of Claim 9, further comprising:
a golf ball configuration, a golf tee configuration, and a 'birdie'
configuration.

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11. The putter head of Claim 2, further comprising a non-triangular configuration
made from non-triangular molds having oval, semi-circular, and non-triangular polygonal
shapes.

10 12. A method for casting a glass putter comprising: providing a pattern for the glass
putter head; casting a master putter glass mold for the glass putter head; loading the putter
glass mold with glass pieces at room temperature; firing in a kiln the glass putter head
mold with loaded glass pieces to obtain a glass putter head melt; annealing the glass
putter head melt through a plurality of cooling steps back to room temperature; drilling a
15 putter shaft hole into the glass putter head; and affixing a putter shaft into the hole in the
glass putter head.

13. The basic glass putter as in Claim 12, wherein the putter is made by a process
that includes a generating a series of patterns comprising a first generation pattern; a
20 second generation pattern; a third generation pattern; and a fourth generation pattern.

14. The method of Claim 12, wherein the master glass putter head mold is loaded
with about 284 grams to about 397 grams of 96 COE soda lime glass pieces.

25 15. The method of Claim 12, wherein the master glass putter head mold is loaded
with about 284 grams to about 397 grams of 90 COE soda lime glass pieces.

16. The basic glass putter as in Claim 12, wherein the master glass putter head with
loaded glass is fired in a kiln from room temperature to about 649 °C to obtain a glass
30 putter head melt in about 6 hours; holding the glass melt for about 30 minutes at about
649 °C, heating one hour to about 807 °C; and holding for about 40 minutes at about 807
°C.

17. The basic glass putter as in Claim 12, wherein the glass putter head melt is
35 annealed by cooling the glass melt in about 20 minutes to about 510 °C; holding for about
two hours at 510 °C; cooling about four and a half hours to 410 °C; holding for about two
hours at 410 °C; cooling about seven hours to about 66 °C; holding for about 5 minutes at

about 66 °C; then turning the kiln off and allowing glass putter heads to cool to room temperature.

18. A bas-relief glass putter made by the process comprising:

5 providing a pattern for a bas-relief glass putter head; casting a master putter glass mold for the bas-relief glass putter head; loading the putter glass mold with glass pieces at room temperature; firing in a kiln the glass putter head mold with loaded glass pieces to obtain a glass putter head melt; annealing the glass putter head melt through a plurality of cooling
10 steps back to room temperature; drilling a putter shaft hole into the glass putter head; and affixing a putter shaft into the hole in the glass putter head.

15 19. The bas-relief glass putter as in Claim 18, wherein the master glass putter head mold is loaded with between about 284 grams and about 397 grams of 90 COE soda lime glass pieces.

20 20. The bas-relief glass putter as in Claim 18, wherein the master glass putter head mold is loaded with between about 284 grams and about 397 grams of 96 COE soda lime glass pieces.